

FLUXOFIL 50 is a seamless copper coated basic flux cored wire for the hardfacing of wear components subjected to heavy impact such as pulleys, rollers, caterpillar track rollers, sprockets, track links, etc. The weld metal is of medium hardness and machinable by chip-forming. Flame and inductive hardening are feasible. Before depositing the final pass, the interpass temperature should not exceed 250 °C. Due to the very tough and crack-resistant weld metal, a buffer layer is not normally necessary.

Classification

EN 14700: T Fe1

Chemical analysis (Typical values in %)

| C | Mn | Si | Cr |
|-----|-----|-----|-----|
| 0.2 | 1.6 | 0.5 | 0.7 |

All-weld metal Mechanical Properties

| Heat Treatment | Hardness |
|----------------|------------|
| As Welded | 225-275 HB |

Gas test: 100% CO₂

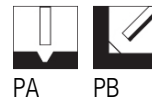
Shielding Gas - EN ISO 14175 : C1

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data

| Packaging Type | B300 |
|-----------------------|------------|
| Diam(mm) / weight(kg) | 16.0 |
| 1.4 | W000281335 |
| 1.6 | W000281336 |